

Work Order ID 59209

Friday, May 28, 2010 9:22:06 AM



Page 1

Item ID: D3909-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Lower Attach Arm

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *205-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3909

B

100

Cut blanks as per folio

0.00



Bandsaw

Memo:

0.00

Jeaspa Bandsaw

CUT BLANK 3.455" LONG

mk 10/06/01

5 0

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA872 AND DWG

FOLIO REV: *AA*

DWG REV: *B*

DEBURR

mk 10/06/01

5 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

out 10/06/01

5

0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

MW 10/06/02

5

0

160

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

10-6-2 (50)

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/03

WLO 06/03

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NOTE: Date & initial all entries

Picklist Print

Friday, May 28, 2010 9:22:12 AM

Page 1

Work Order ID: 59209



Parent Item: D3909-3



Parent Item Name: Fwd Lower Attach Arm

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP REV:A NEW ISSUE 09-11-26 JLM VERIFIED BY:DD IPP
Rev:B chg blank size in seq 100 DD 10.02.10 verified JLM IPP Rev:C as per
dwg revB DD 10.04.20 verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M303B0.750X1.500		Purchased	No			100	f	1.8839	0.3333	4.210105			



303 BAR .750" X 1.500"



Location

Loc Qty

Loc Code

MAT53

1.8839

113310

1.8839

1.8839 and 10/6/01

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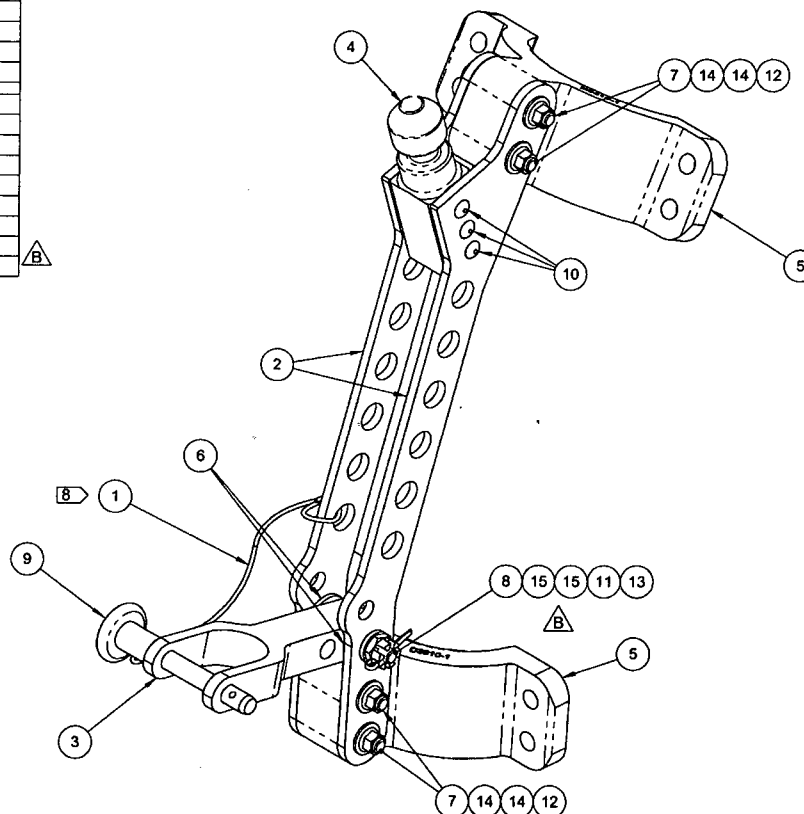
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.74 lbs
- 8) ATTACH TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57209
PS 10-5-28

RELEASED
2010-04-07
WJP

B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10. SHT 5, D3909-5 REVISED: SECTION A-A & DIM Ø0.850 REMOVED. SIDE VIEW ADDED. DIM: 2.68 WAS 2.38 REF. 1.30 WAS 1.00, 0.250 WAS 0.220. R0.06 WAS R0.05. WEIGHT REVISED.		JPH	10.04.06
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		DRAWING NO. D3909	
CHECKED	<i>[Signature]</i>		REV. B SHEET 1 OF 5	
MFG. APPR.	<i>[Signature]</i>		TITLE FWD X-TUBE LUG ASSY	
APPROVED	<i>[Signature]</i>		SCALE NTS	
DE APPR.	<i>[Signature]</i>		DATE 10.04.06	
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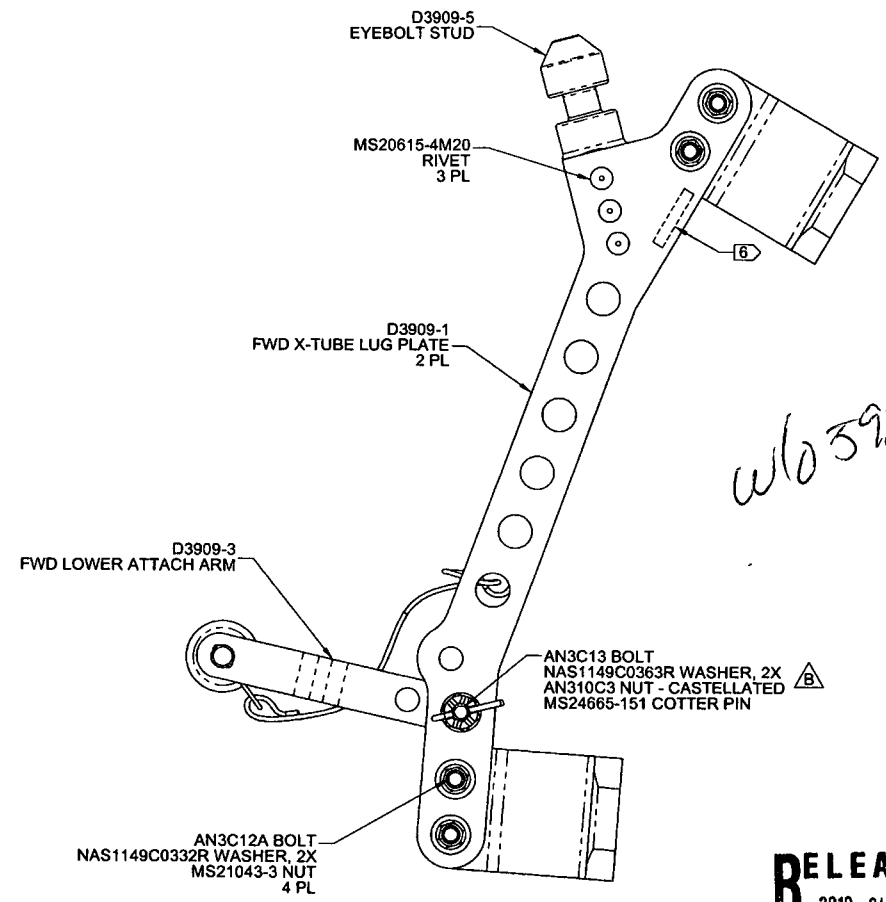
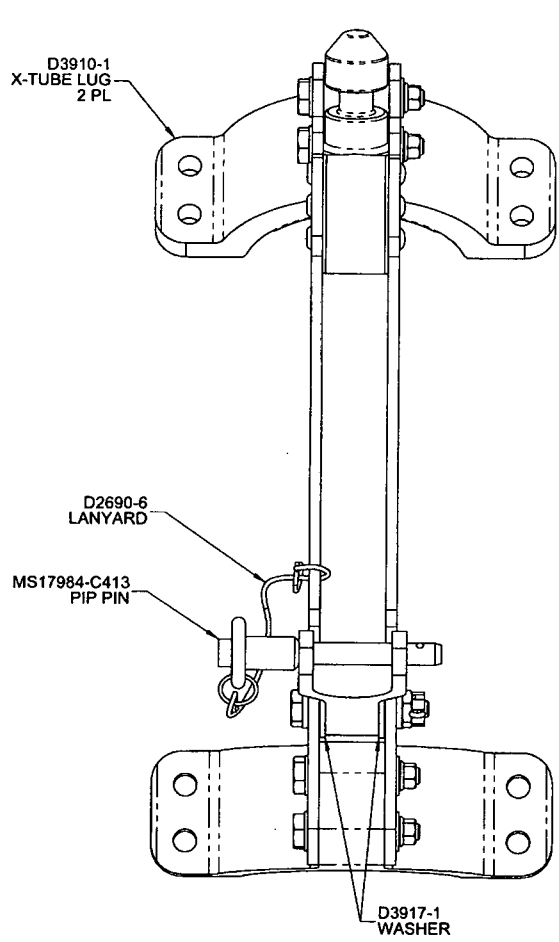
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-04-07
MP

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3909	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	SCALE NTS
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DATE	10.04.06		

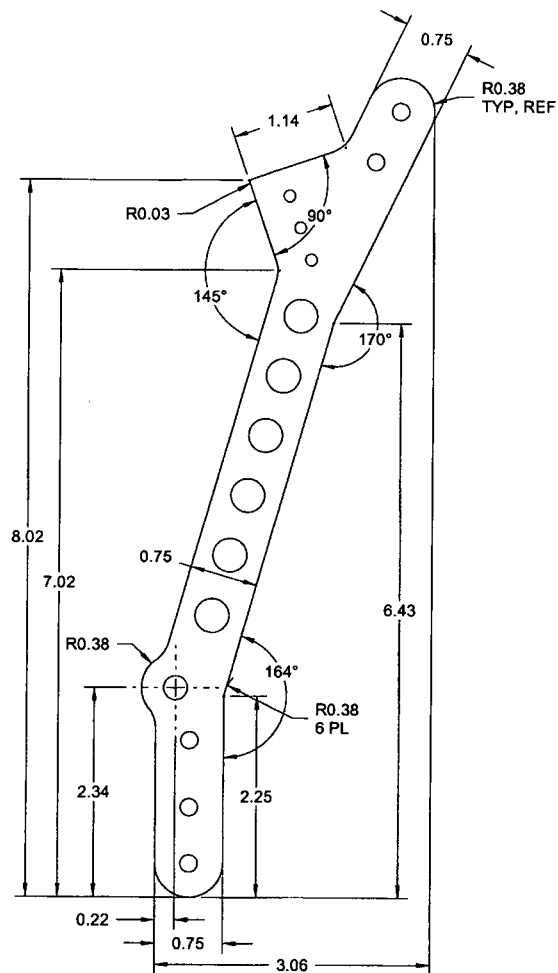
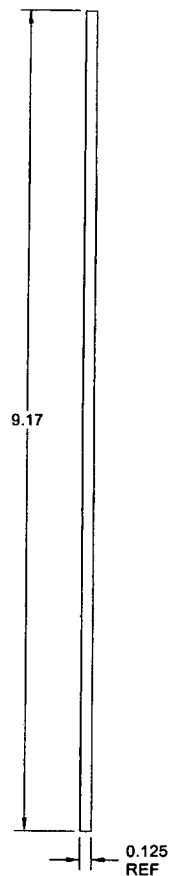
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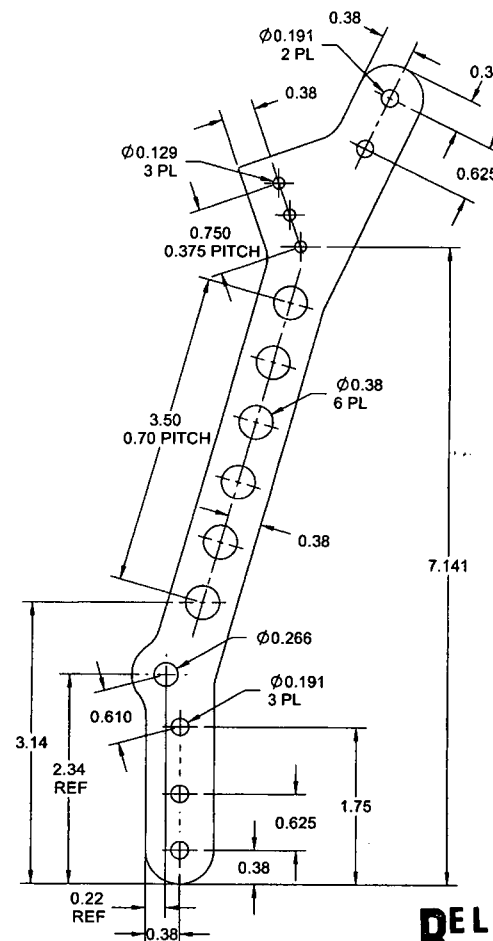
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NOTE: Date & initial all entries



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

RELEASED
2010-04-07

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3909	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD X-TUBE LUG ASSY	NTS
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w/059209

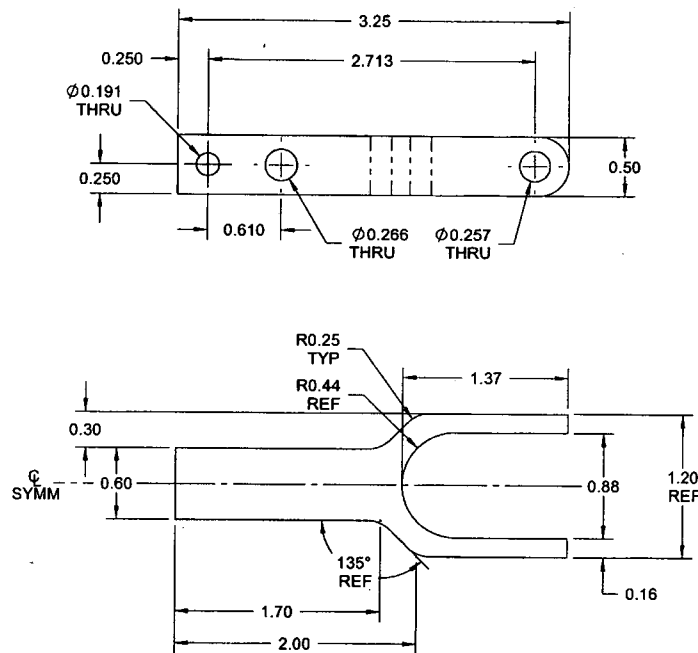
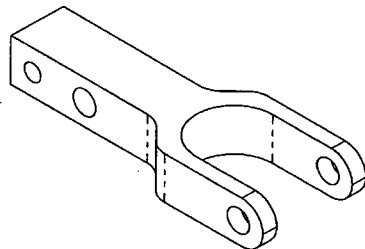
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NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

w/o 39289

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

RELEASED
2010-04-07
WJ

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

D

C

B

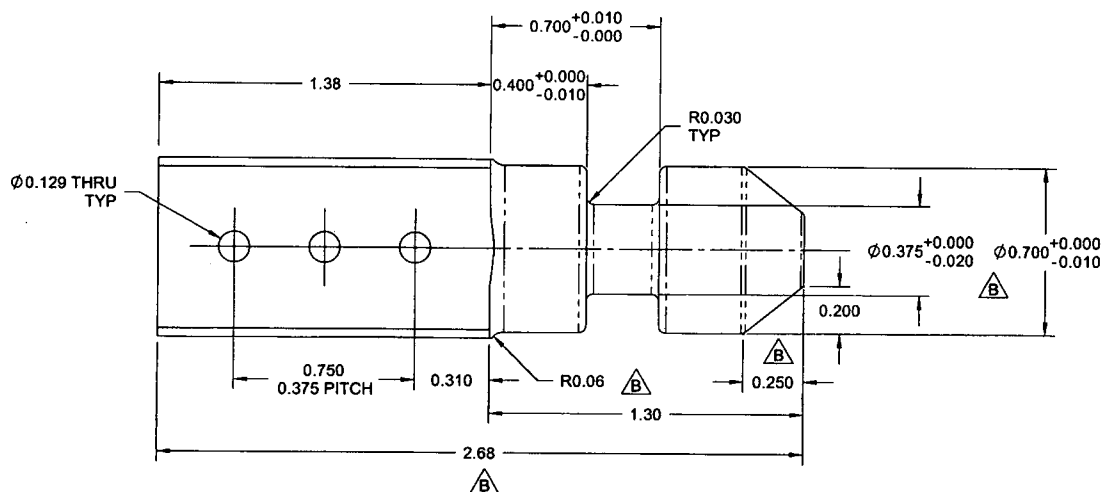
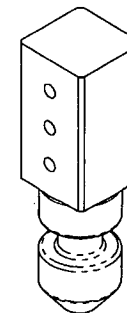
A

D

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B

A







D3909-5 EYEBOLT STUD

RELEASED
2010-04-07
JMP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.31 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3909	REV. B
MFG. APPR.		SHEET 5 OF 5	
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